

Date: Thursday, 5/3/2007 11:40:04 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	X-TUBE 412
Job Number	32211		
Estimate Number	12727		
P.O. Number	N/A	Part Number	D412664245
This Issue	5/3/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D412-664-245 REV C
First Issue	N/A	Project Number	N/A
Previous Run	31600	Drawing Revision	C
Written By		Material	N/A
Checked & Approved By	JLJ 07/05/03	Due Date	8/6/2007
Comment	Est Rev:A New Issue 07-02-14 JLM	Qty:	1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	 <i>packaged in B3221</i>
		Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPPD412-664-205	CHG001 N/A 8/6/07/05/22
2.0	D6009129	Crosstube Material	 <i>SB 07/05/22</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D6009-129 Crosstube 26548 Check OD = 3.500"; ID = 2.250"	
3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE	 <i>SB 07/05/22</i>
		Comment: 1-TURN AS PER FOLIO FA690 & DWG D412-664-245, FOLIO REV: 11 DWG REV: L	
		2-DEBURR AS REQUIRED	<i>SB 07/05/22</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <i>SB 07/05/22</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	 <i>MS 07/05/22</i>
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: X-TUBE 412

Job Number: 32211

Part Number: D412664245

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JB 7-5-28

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-5 - 28

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 7-5-28

9.0 QC3/5

INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

7-5-29

10.0 BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

EL 7-5-29

11.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

2008-04-01

12.0 D36061

CUFF



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CUFF

Batch: R31635

13.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Rivet holes as per Dwg D412-664-245

JB 7-6-5
JB 7-6-14
JB 7-6-5

2-Drill pilot holes in tube as per Dwg D412-664-245

3-Ream hole to finish size in tube as per Dwg D412-664-245

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 32211		Part Number: D412664245
Job Number:		
Seq. #:	Machine Or Operation:	Description :
4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-245 <i>JB 7-6-5</i>		
14.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1 <i>JB 7-6-5</i>		
15.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>2006.06</i> 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
16.0	QC5 	INSPECT WORK TO CURRENT STEP <i>2006.06</i> 
Comment: INSPECT WORK TO CURRENT STEP		
17.0	OUTSIDE SERV.10 	OUTSIDE SERVICES -LG 
Comment: Sub-Contracting OUTSIDE SERVICES Liquid Penetrant Inspection as per QSI 038Or Issue P/O: <u>3960</u> LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order <i>c207/06/12①</i>		
18.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Inspect for transit damage Ensure copy of NDT results attached to work order. <i>2/2/13 ①</i>		
19.0	QC5 	INSPECT WORK TO CURRENT STEP <i>2006.19①</i> 
Comment: Inspect for damage & ensure results are as per Dwg D412-664-203		
20.0	LANDING GEAR 1 	LANDING GEAR RESOURCE 1 
Comment: LANDING GEAR RESOURCE 1 1-Rivet Cuffs as per Dwg D412-6647-245. with Sika flex in Between tube & Cuff <i>DP 7-6-14</i> A/R SIKAFLEX -241/291 BATCH: <u>M103561</u> <i>DP 7-6-14</i> <u>EXP-7-10-1</u> <i>DP 7-6-14</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 32211		Part Number: D412664245
Job Number:		
Seq. #:	Machine Or Operation:	Description :
21.0	CR3212407	CHERRY RIVET
Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s) CHERRY RIVET Batch: M104071	DP	7-6-14 45 P10
22.0	SPRAY PAINTING	SPRAY PAINTING
Comment: SPRAY PAINTING	1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2	
23.0	QC14	INSPECT SPRAY PAINT
Comment: Inspect Spray Paint Wrap in plastic bag to protect from scratches	m 07-06-21 (1)	
24.0	D31891	Chafing Shield
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Chafing Shield Batch: 31147	2T 07-06-21	
25.0	D3595	Rubber Cushion (per sq ft)
Comment: Qty.: 0.0536 sf(s)/Unit Total : 0.0536 sf(s) Rubber Cushion Cut to .630" X 5.7" X 2PCS Batch: 32894	2T 07-06-21	
26.0	D28961	Support
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch	27266 2T 07-06-21	
	1 D2896-1 Support	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-19	21.1	Add QCS for assx inspection <i>Perm Change</i> Done <i>Done</i>		07-06-19	1	07-06-19	07-06-19
		QCS					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 32211		Part Number: D412664245
Job Number:		
Seq. #:	Machine Or Operation:	Description :
27.0	D2856600	Abrasion Strip
Comment: Qty.: 0.9450 f(s)/Unit Total : 0.9450 f(s) X Batch: 266T0		RT 07-06-21
28.0	MS2192028	Clamp(per MIL-DTL-8783C)
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) X Pick: Qty Part number Description Batch 4 MS21920-28 Clamp 162534		RT 07-06-21
29.0	MS2192030	clamp(per MIL-DTL-8783C)
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) X batch: 101568		RT 07-06-21
30.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 Assemble as per Dwg D412-664-245 Install Chaffing Sheilds Instal support with magnobond 6398 per dwg D412-664-245, cure for 12hrs before packaging. Time & date of application: 2:30 07-06-21 Batch: 107628		RT 07-06-21
31.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		2006-220
32.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-664-205		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/22
 QA: N/C Closed: _____ Date: _____

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Drawing Name: X-TUBE 412

Job Number: 32211

Part Number: D412664245

Job Number:



Seq. #:

Machine Or Operation:

Description :

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

Time & date of packaging: 12-30

07/8/22 ①

Location: _____

PPP 32184

PPP Rev: _____

33.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

07/06/22

Job Completion



U 07.06.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

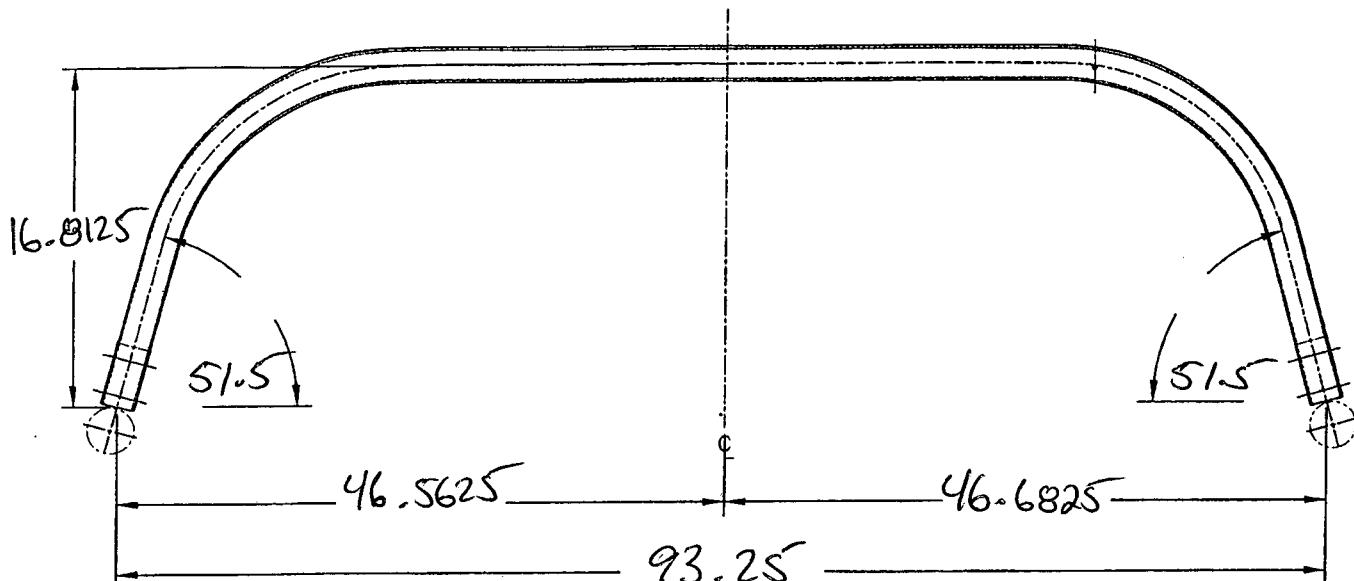
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32211
Description: Crosstube Low Narrow Aft (412)	Part Number:	D412-664-205
Inspection Dwg: D412-664-245 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	16.69	16.95
1/2 Span	46.47	46.73
Angle	49°	52°
Total Span	92.94	93.46



Comments

QC15 Inspection	
Date	0706.04

Rev	Date	Change	Revised by	Approved
A	07.04.27	New Issue	KJ/JM	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D412-664-245	SHEET 1 OF 3
DATE		TITLE	SCALE
07.03.29		CROSSTUBE ASS'Y (412 LOW-N AFT)	NTS
A	06.12.01	NEW ISSUE	
B	07.03.01	CHG CUFF AREA, CHG RUBBER CUSHION	
C	07.03.29	CHG RIVET AND RUBBER CUSHION	

RELEASED07.04.24 *[Signature]***PARTS LIST:**

Qty	Part Number	Description
X	D412-664-245	CROSSTUBE ASSEMBLY (412 LOW-NARROW AFT)
1	D6009-129	CROSSTUBE
2	D2856-600-1009	ABRASION STRIP
1	D2896-1	SUPPORT
2	D3189-1	CHAFING SHIELD
2	D3595-063-570	RUBBER CUSHION
2	D3606-1	CUFF
44	CR3212-4-07	RIVET (OR M7885/3-4-07)
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

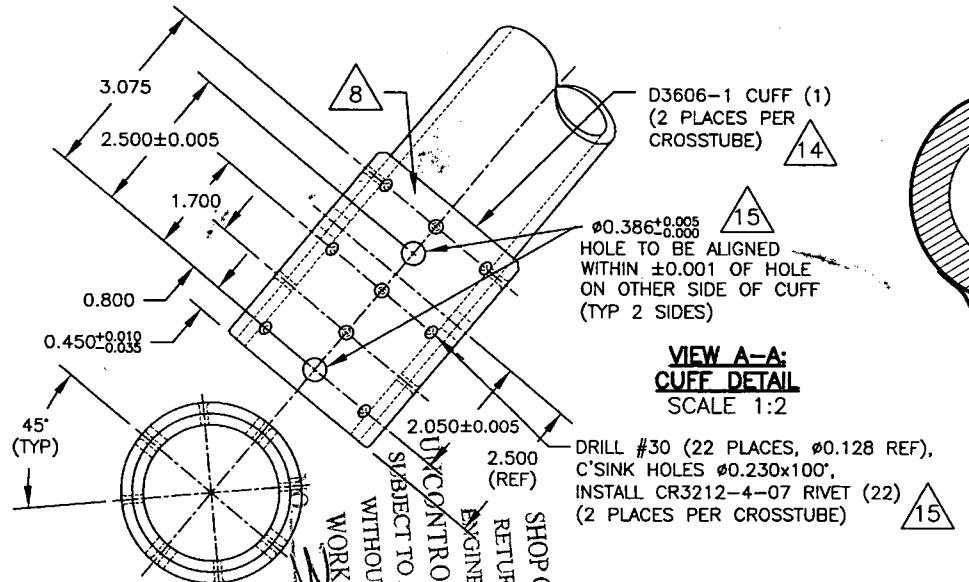
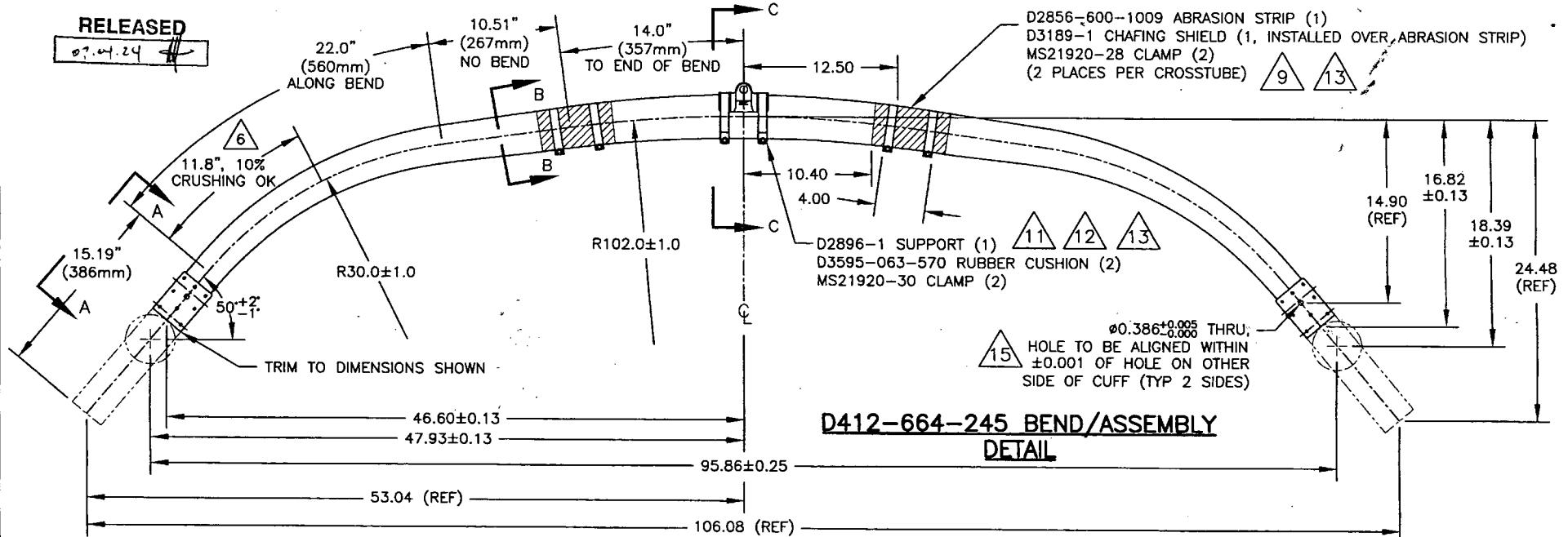
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 123.59 ± 0.020 (BEFORE BENDING/TRIMMING)
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
 - 4) PART IS SYMMETRIC ABOUT CENTERLINE.
 - 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
 - 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
 - 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
 - 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
 - 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
 - 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
 - 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
 - 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE CROSSTUBE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE RETURN TO CROSSTUBE SUPPORT.
 - 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY NUT AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
 - 14) INSTALL D3606-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A TO AMENDMENT LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
 - 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.
- STOP COPY
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32211

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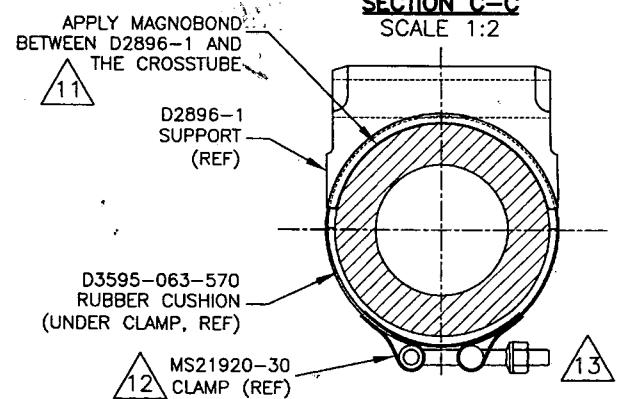
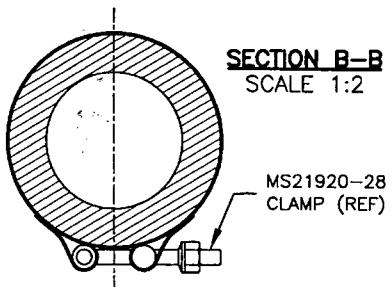
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DESIGN

gp

REVISION

0

DATE

07.03.29

DRAWN BY

gp

APPROVED

gp

REV. C

TITLE

CROSSTUBE (412 LOW-NARROW AFT)

DRAWING NO.

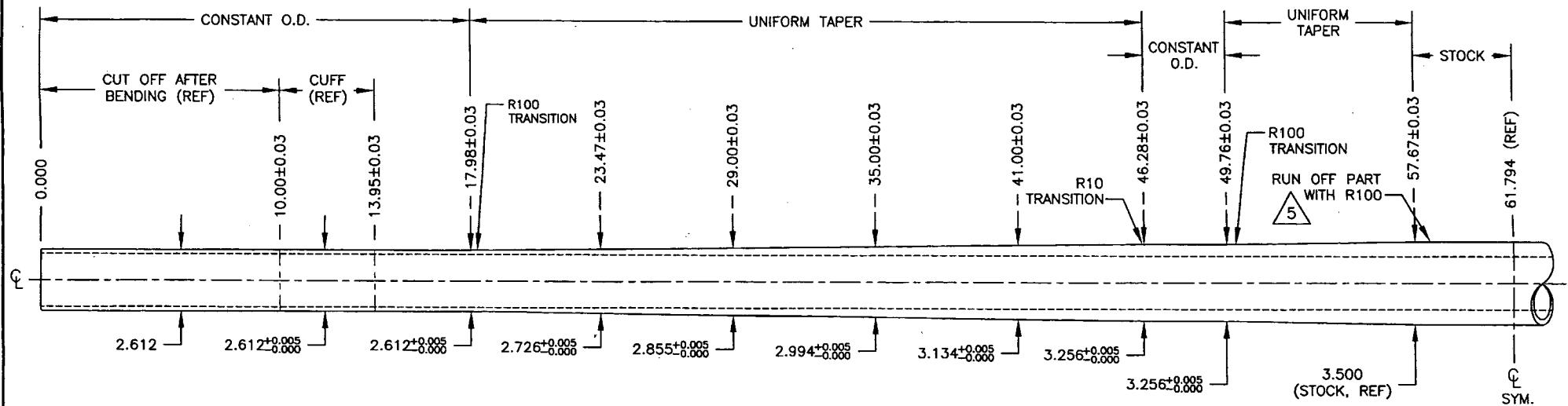
D412-664-245

SHEET 2 OF 3

SCALE

DART

DART AEROSPACE LTD.
HANDBURY, ONTARIO, CANADA



D412-664-245 MACHINING DETAIL

RELEASED

07.04.19

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WORK ORDER
NO 221

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		9P	9P			
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		DATE		TITLE	SCALE	
		07.03.29		CROSSTUBE (412 LOW-NARROW AFT)	1:4	

DART AEROSPACE LTD	Work Order:
Description: AX TUBE 412	Part Number: D41261V148
Inspection Dwg: D41261V148 Rev: C	Page 1 of 1

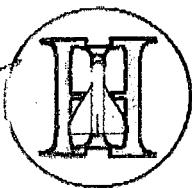
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.612	+.005 -.002	2.615				
2.612	"	2.615				
2.726	"	2.726				
2.855	"	2.855				
2.994	"	2.994				
3.134	"	3.134				
3.256	"	3.256				
3.256	"	3.256				
2.612	"	2.615				
2.612	"	2.815				
2.726	"	2.726				
2.855	"	2.855				
2.994	"	2.994				
3.134	"	3.134				
3.256	"	3.256				
3.256	"	3.256				
123.58	.030	123.58				

Measured by:	S.B	Audited by:	M.B	Prototype Approval:	
Date:	07/05/24	Date:	01/05/24	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



HeathAir
INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tel.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36657

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT/COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of six (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (2) P/N D206-667-203 S/N's B30434 & B30433

Qty. (2) P/N D206-667-103 S/N's B32139 & B32138

Qty. (1) P/N D412-664-245 S/N B32211

Qty. (1) P/N D212-664-201 S/N B32151

RADIOGRAPHY

ULTRASONIC

PENETRANT

MAGNETIC PARTICLE

EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on six (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

Six (6) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

DATE June 13, 2007

INSPECTED BY:

INSPECTION STAMP/initials
Not Required

CUSTOMER: Dart Aerospace

P.O. NUMBER:

CONTACT NAME:

CUSTOMER INFORMATION

ADDRESS:

LABOUR	②	\$
MATERIALS	②	
TRAVEL EXPENSES	②	GST
HOTEL EXPENSES	②	PST

INVOICE NO.

TOTAL \$